



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3312-03-1
Job Sheet 189252



Part No: RBE350A93-3312-03-1

Job Qty: 10 pcs

Part Name: Receiver



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	SL-2500Y - 1	10 pcs	2/8/19	2/8/19	0.00	10.00	SL-2500Y - 1	
130	QC 2	10 pcs	2/8/19	2/8/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/12/19

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140 QC 8	10 pcs	2/8/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	mL 19/02/12
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
142 Outsource - 12 - Black Oxide	10 pcs	2/8/19		GRO002-VC	5
144 Packaging 2-1 - Receive - B4B	10 pcs 15/10	2/8/19	0.00 0.00	Packaging 2 - 1 - B4B	CZ 19-02-14 FEB 22 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	

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146	QC 6	10 pcs	2/8/19	0.00	0.00	QC 6 - 38	
						QC 6 - 42	
						QC 6 - 9	DAS
						QC 6 - 68	MAR 01 2019 68
						QC 6 - 61	9-89
200	Packaging 3-1 - Stock - B4B	10 pcs	2/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	DAS
						Packaging 3 - 8 - B4B	28
						Packaging 3 - 9 - B4B	9-89
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
210	QC 21 - SA	10 pcs	2/8/19	0.00	0.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21 MAR 01 2019

Part Op 120 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per DWG. FB898 FOLIO REV: 9-89 DWG REV: 2-Debur

Descriptions: 2-Debur
 130 - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
 140 - (QC8- Inspect parts - second check)
 142 - (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO 042612 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required
 144 - (Receive & Inspect for Damage & Mat'l Certs)
 146 - (QC6- All purchased or subcontracted products)
 200 - (Identify as per dwg & Stock Location:)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

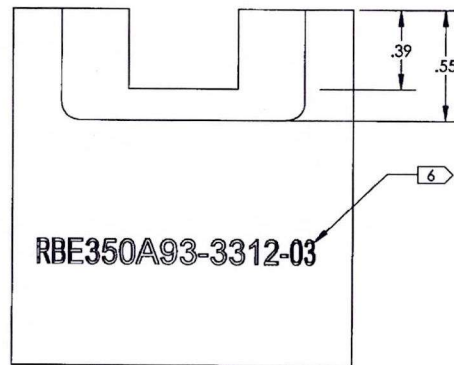
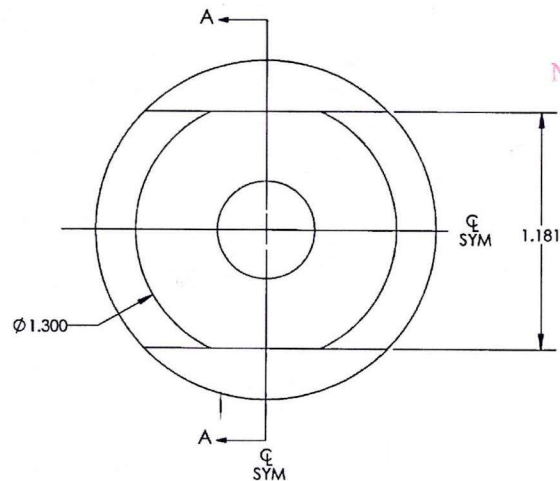
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.000	AISI 4140 Quenched & Tempered Steel Round Bar 2.000" Dia. 1.6000 ft (.16 ea)	120-SL-2500Y - 1		5082798 304

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-2500Y - 1	MT-4140QT-R2.000	2	9	0
Part Specifications				
Specifications could not be found.				

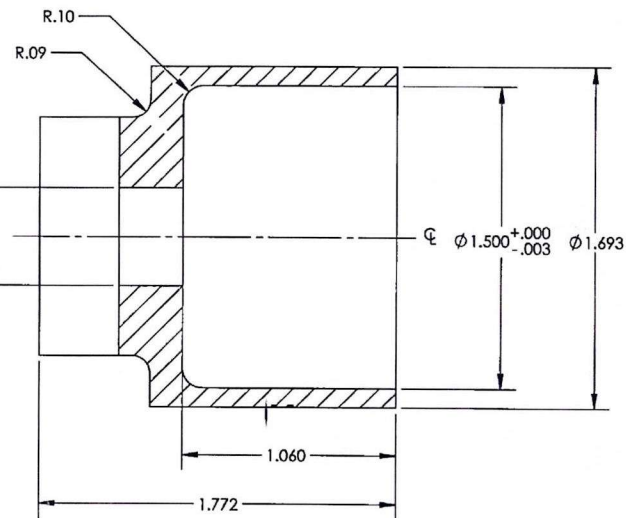
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189252-MW
19-01-22

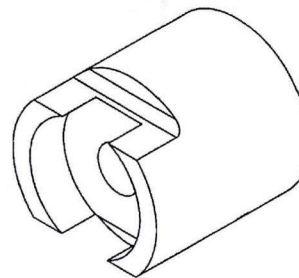
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, DIMENSION .473 CHANGED TO .484, MACHINE ENGRAVE S/N & MADE IN USA REMOVED, SPEC FOR BLACK OXIDE CHANGED, DIMENSION .54 REF ADDED, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION .55" & .39 ADDED, 28-32 Rc REMOVED	18-582	18.3.1	VM	ML



RBE350A93-3312-03



SECTION A-A



RBE350A93-3312-03-1 RECEIVER

- NOTES:
- 1) MATERIAL: 4140/4142 OR 17-4PH-H900 SS
 - 2) HEAT TREAT: N/A
 - 3) FINISH: 4140/4142 = BLACK OXIDE / 17-4PH = NONE
 - 4) SPEC: 4140/4142 = MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4 / 17-4PH = N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: MACHINE ENGRAVE T/N "RBE350A93-3312-03", 0.010" DEEP

DART AEROSPACE		Hawkesbury, Ontario, Canada	
RECEIVER			
PART NO. RBE350A93-3312-03-1		REV G	
TOOL NO. RBE350A93-3312-03		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 12/27/2017	INITIALS AND DATE	TOLERANCES: XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
DRAWN BY: VM 03/01/2018			
CHECKED BY: VM 03/01/2018			
MFG REVIEW BY: DD 03/01/2018			
APPROVED BY: ML 03/01/2018		SCALE: NTS	SHEET 2 OF 6
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042612



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042612
PO Date: 2/14/19
Due Date: 2/22/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189091	RBT400325	Tail Boom Nut Socket (407) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/22/19	12 pcs	0 pcs	12 pcs	\$2.1136363/pcs	\$25.36
							12 X	FEB 22 2019			
2	189453	RBT18560-9	Cross Bar -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/22/19	21 pcs	0 pcs	21 pcs	\$2.1136363/pcs	\$44.39
							21 X	FEB 22 2019			
3	189252	RBE350A93- 3312-03-1	Receiver (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	2/22/19	15 pcs	0 pcs	15 pcs	\$3.35/pcs	\$50.25
							15 X	FEB 22 2019			

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Canada

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PURCHASE ORDER

PO042612



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

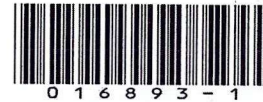
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/15/19 1:15 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

016893- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
21-Feb-2019		SPARTAKOS BOUNTOURIS				042612 ✓			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item/Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	RBT400325 ✓ Rev.	RBT400325 01 -OXIDE BLACK [OXIDE BLACK MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12 ✓	0	0	0	0
2	RBT18560-9 ✓ Rev.	RBT18560-9 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	21	21 ✓	0	0	0	0
3	RBE350A93-3312-03-1 ✓ Rev.	RBE350A93-3312-03-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OILMIL-PRF-16173 GRADE 3 CLASS 1	BLACK-OXIDE CH	15	15 ✓	0	0	0	0

*You already have
at shop*

42649

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.